

Date: Thursday, 12/6/2007 10:50:49 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 36152	
Estimate Number : 10551	
P.O. Number : <i>N/A</i>	Part Number : D31151
This Issue : 12/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3115 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/5/2007 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 24696	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/10/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est A 02.05.09 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.0234 sf(s)/Unit Total : 0.1171 sf(s)
 2024-T3 .063 sheet

Matl: 2024-T3 (QQ-A-250/4) .063" thick (M2024T3S.063)

Batch *102940* *IB 07-12-10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3115-1

Dwg Rev: *B*

Prog Rev: *B*

IB 07-12-10



2-Deburr if necessary

3.0	QC2
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INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-10

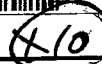
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07-12-11



5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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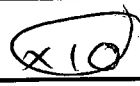


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IB

07-12-12



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FL 07/12/12 (10)

7.0

POWDER COATING

POWDER COATING



M 105642



(10X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/12/13

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 606

SS 07/12/13 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/14

Job Completion

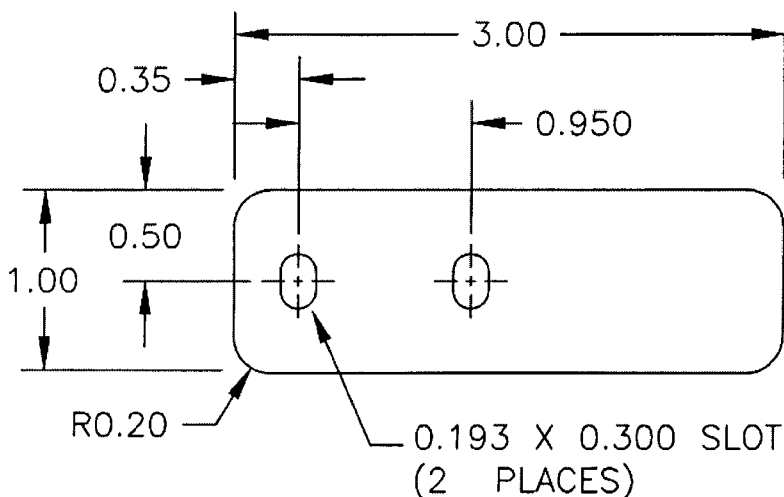


U 07.12.14



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3115	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.23



D3115-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36152

NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-233
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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